




shp 10/03

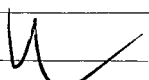


Work Order ID 67165

Wednesday, March 09, 2011 11:35:16 AM





PRELIMINARY ISSUE

Item ID: D4165-9 *First pattern only* Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Angle
Start Date: 3/9/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/10/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4165	PA1								

100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
7024 - 040	Dwg Rev: PA1								
	Prog Rev: PA1								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

B11-3-9

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B11-3-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries

Work Order ID 67165

Wednesday, March 09, 2011 11:35:16 AM



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Item ID: D4165-9

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Angle

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
135 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Inspector is AAS

Done only

Sub 3/10

1 BR 11-3-10

11/3/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67165

Wednesday, March 09, 2011 11:35:16 AM

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Item ID: D4165-9

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Angle

Start Date: 3/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/3/10

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Roberts

11.03.10

POSITIVE RECALL

EFFECTIVE 11/3/09 AUTH U

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 11:35:14 AM

Page 1

Work Order ID: 67165



Parent Item: D4165-9



Parent Item Name: Angle


Start Date: 3/9/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	184.0595	0.634	0.667368			
													
2024-T3 .040 sheet													



1811-3-9

Location

Loc Qty

Loc Code

MAT

11.8

114415

11.8

MAT22

172.2595

110305

21.93

111786

7.66

112291

14.25

112331

52

113162

76.4195

110305

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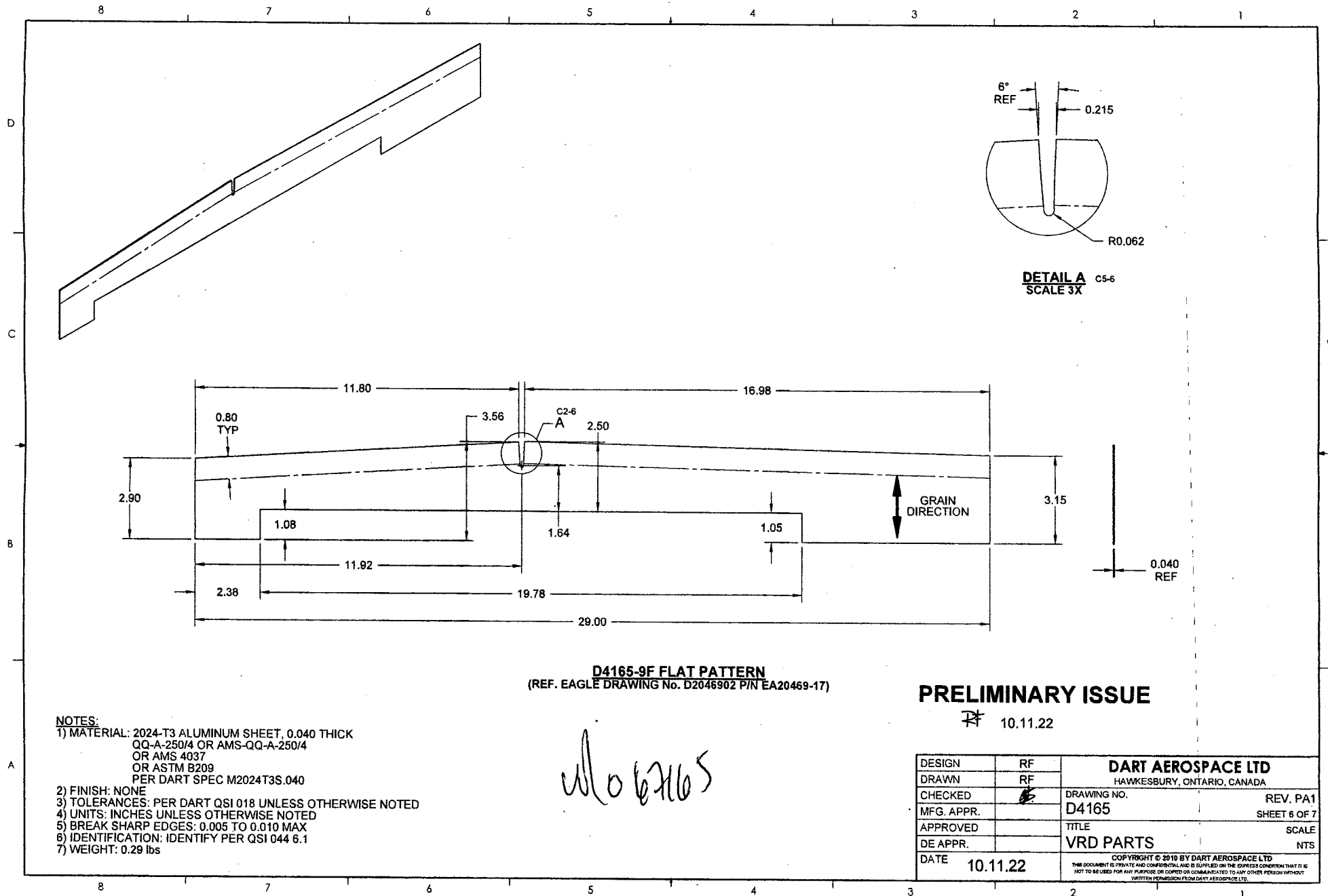
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4165-9F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-17)

PRELIMINARY ISSUE

10.11.22

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs

W067165

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4165	REV. PA1
MFG. APPR.		TITLE VRD PARTS	SHEET 6 OF 7
APPROVED			SCALE NTS
DE APPR.			
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

